

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001646**Date Inspected:** 17-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	No welding performed		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	Tower Mock-Ups, OBG Components		

Bridge No: 34-0006**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

114-meter Mock-Up, Z. P. M. C. personnel drilled bolt holes in bolted splice connection plates.

114-meter Mock-Up, upper, Rotate and relocate the Mock-Up. Z. P. M. C. personnel started removing bolts from the previously installed exterior bolt splice connection plate. The upper and lower 114-meter Mock-Up sections were placed adjacent to one another.

Z. P. M. C. personnel delivered four (4) uncut steel plates to be cut.

Z. P. M. C. appears to be training new personnel in the operation of Mag Drills and the use of acetylene cutting torches.

Bay 3) Z. P. M. C. personnel are grinding various WT stiffeners prior to being welded.

Z. P. M. C. Quality Control personnel were checking the flatness of BP001-01, while it is turned upside down and after the stiffeners are tacked in place.

Z. P. M. C. Quality Control personnel were checking the plumbness of stiffeners on BP005-01, after the

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completion of the fillet weld.

Z. P. M. C. personnel were doing Heat Straightening on BP001-01 stiffeners.

Z. P. M. C. personnel were doing heat straightening on SP005-01 plate.



Summary of Conversations:

The QA Inspector had no significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
